



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

RB KIT 407M-31
Job Sheet 171592



5052158

DAS
13
9-89

MAR 16 2018

Part No: RB KIT 407M-31

Job Qty: *3* pcs

Part Name: Gauge Pin



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 2/5/18

Job Tracking No:

Due Date: 2/16/18

Created By: Marie Lajeunesse

Type: Stock

Description:

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	6 Ea	2/16/18	2/16/18	0.00	0.00	Start Up Container		<i>At 18/03/21</i>
100	Outsource	6 pcs	2/16/18	2/16/18	0.00	0.00	Outsource16		<i>At 18/03/21</i>
110	Packaging	6 pcs	2/16/18	2/16/18	0.00	0.00	Packaging2		<i>At 18/03/21</i>
120	QC	6 pcs	2/16/18	2/16/18	0.00	0.00	QC6		<i>38</i>
130	Packaging	6 pcs	2/16/18	2/16/18	0.00	0.00	Packaging3	<i>GA</i>	<i>MAR 23 2018</i>
140	QC	6 pcs	2/16/18	2/16/18	0.00	0.00	QC21		<i>GA090</i>

Part Op 100 - 1-Issue P/O to KG Grinding; P/O *039202* (Ship quantity req'd: 1 vial makes 4 pins) 2-Grind as per DWG. 3-Descriptions: Certificate of Conformity is required

DAS
21
9-89

MAR 27 2018

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
GM10-192	Gauge Pin 0.192Ø	6 (1 ea)	100-Outsource	<i>5044653</i>

6m9-1122

3pin

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
100-Outsource	GM10-192	6	0	0

Part Specifications

Specifications could not be found.

DQA: _____ Date: _____

**WORK ORDER NON-CONFORMANCE / UPDATE**

QA Closed: _____ Date: _____

Work Order update only ☐

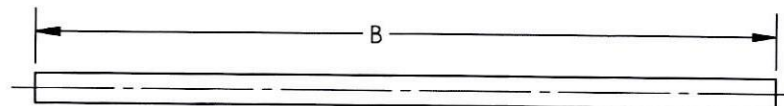
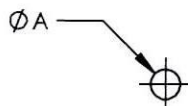
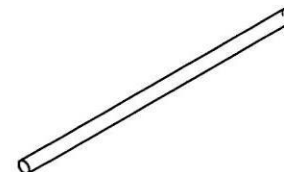
Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS <table style="width:100%; border: none;"> <tr> <td style="width:15%;">Skid-tube ☐</td> <td style="width:15%;">Cross tube ☐</td> <td style="width:15%;">Water Jet ☐</td> <td style="width:15%;">Engineering ☐</td> </tr> <tr> <td>Machining ☐</td> <td>Small Fab ☐</td> <td>Prod. Eng. Coord. ☐</td> <td>Quality ☐</td> </tr> <tr> <td>Thermoforming ☐</td> <td>Finishing ☐</td> <td>Rec/Store/Packaging ☐</td> <td>Other ☐</td> </tr> <tr> <td>Large Fab ☐</td> <td>Composite ☐</td> <td>Supplier ☐</td> <td></td> </tr> </table>				Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐																																																															
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PART NO: RB KIT 407M-31 Serial No/Batch: S052158 Revision: Operation: Change No: Packaging Mfg Date: 03/16/18 Job No: 171592					Completed By																																																																														
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REVISIONS				DATE	INITIAL	APPROVED
REV	ECR	DESCRIPTION				
2	17-0085	-01 THRU -31 ADDED GUAGE PIN DIMENSIONS TABLE.			4/6/2017	RJC JAG

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 171592 MLS

18-02-05



GUAGE PIN DIMENSIONS

PART NUMBER	ØA	B
-01	(Ø.0240)	1"
-03	(Ø.0400)	1"
-05	(Ø.0540)	1"
-07	(Ø.0600)	1"
-09	(Ø.0800)	1"
-11	(Ø.0960)	1"
-13	(Ø.1080)	1"
-15	(Ø.1200)	1"
-17	(Ø.1440)	1"
-19	(Ø.1440)	1/4"
-21	(Ø.1600)	1"
-23	(Ø.1600)	1/4"
-25	(Ø.1728)	1"
-27	(Ø.1728)	1/4"
-29	(Ø.1800)	1"
-31	(Ø.1920)	1"

-01 THRU -31
GUAGE PIN

DART AEROSPACE	
TITLE SPLINE MEASURING KIT ASSY	
DWG NO. RB KIT 407M-01 THRU -31	REV 2
MAT'L HEAT TREAT FINISH	UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES .XXX ± .005 FRACTIONS ± 1/8 .XX ± .01 ANGLES ± 5° .X ± .1 SURFACES = 125/✓
SPEC	1. BREAK ALL SHARP EDGES .015 x 45° OR .015R
DRAWN BY: CLOUGH	2. DIMENSIONAL LIMITS APPLY AFTER PLATING
CHECKED: MACKOVJAK	3. INTERPRET DIM AND TOL PER ASME Y14.5M-2009
OPPS APPR: ANDERSON	
QA APPR: LINDSAY	USED ON MODEL
APPROVED: GILBERT	BELL 407
SCALE 4:1	DATE 12/7/2016 SHEET 2 OF 5

QA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date :	Step #:	QTY Effective :		MRB (QSI042) Approval	
Description Work Order Deviation		Disposition		Completed By	
				Lead hand / Supervisor Approval Verification	
				QC / QA Coordinator Approval	
Root Cause		FAULT CATEGORY			
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐
Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐
Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐
Equip/Tooling ☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐
Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐
Material ☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐
Internal Transport ☐	Poor Information ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐
Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐
LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐
Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐
Past Expiry Date ☐	Manufacturing Process ☐	OTHER :			
Misidentified ☐	Past Due ☐				



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

PURCHASE ORDER

PO039202

Supplier: AFF001-VC
Affutage K.G. Inc.
11455 Philippe Panneton Ave.
Montreal
QC
H1E 4M1 Canada
Phone: 514 323 0192 514 323 6631
Fax: 514 323 6631

PO No: PO039202

PO Date: 3/5/18

Due Date: 3/14/18

Purchase Order

Revision:

Revision Date:

Ship-To Contact: Lavoie, Chantal
clavoie@dartaero.com

REVISED

Ship To: 1270 Aberdeen Street
Hawkesbury
ON
K6A 1K7 Canada
Phone: 613-632-5200

Via: Ground

Pymt Terms: Net 30

Freight Terms:

Special Comments:

Items

Line Item	Job	Part	Description	Status	Due Date	Order Quantity	Received Quantity	Balance	Unit Price (CAD)	Extended Price
1	170734	RBST4241-5	Roller ISSUE P/O: _____ TO KG GRINDING. MANUFACTURE AS PER DWG. SHIP QTY REQUIRED OF 89031009	Firmed	3/14/18	6 pcs	0 pcs 6x	6 pcs AT	\$12.00/pcs	\$72.00
2	173095	RBST2854-5	Roller ISSUE P/O: _____ TO KG GRINDING. MANUFACTURE AS PER DWG. SHIP QTY REQUIRED OF 89031009 1 pin make 4 pcs	Firmed	3/14/18	26 pcs	0 pcs 26x	26 pcs	\$12.00/pcs	\$312.00
3	170733	RBST1016-5	Roller ISSUE P/O: _____ TO KG GRINDING. MANUFACTURE AS PER DWG. SHIP QTY REQUIRED OF 89031009	Firmed	3/14/18	6 pcs	0 pcs 6x	6 pcs	\$12.00/pcs	\$72.00
4	171045	RBST1007-5	Roller ISSUE P/O: _____ TO KG GRINDING. MANUFACTURE AS PER DWG. SHIP QTY REQUIRED OF 89031009 1 pin make 3 pcs	Firmed	3/14/18	6 pcs	0 pcs 6x	6 pcs	\$12.00/pcs	\$72.00
5	RB KIT 407M-09		Gauge Pin 1-Issue P/O to KG Grinding; P/O _____ (Ship quantity req'd: 1 vial makes 4 pins) 2-Grind as per DWG. 3- Certificate of Conformity is required	Firmed	3/14/18	3 pcs	0 pcs 3x	3 pcs	\$12.00/pcs	\$36.00

3/16/2018

PURCHASE ORDER

Items										
Line Item	Job	Part	Description	Status	Due Date	Order Quantity	Received Quantity	Balance	Unit Price (CAD)	Extended Price
13	171576	RB KIT 407M-03	Gauge Pin 1-Issue P/O to KG Grinding; P/O _____ (Ship quantity req'd: 1 vial makes 4 pins) 2-Grind as per DWG. 3- Certificate of Conformity is required	Firmed	3/14/18	3 pcs	0 pcs	3 pcs	\$12.00/pcs	\$36.00
14	171575	RB KIT 407M-01	Gauge Pin 1-Issue P/O to KG Grinding; P/O _____ (Ship quantity req'd: 1 vial makes 4 pins) 2-Grind as per DWG. 3- Certificate of Conformity is required	Firmed	3/14/18	3 pcs	0 pcs	3 pcs	\$12.00/pcs	\$36.00
15	171592	RB KIT 407M-31	Gauge Pin 1-Issue P/O to KG Grinding; P/O _____ (Ship quantity req'd: 1 vial makes 4 pins) 2-Grind as per DWG. 3- Certificate of Conformity is required	Firmed	3/14/18	3 pcs	0 pcs	3 pcs	\$12.00/pcs	\$36.00
Grand Total:										\$960.00
Order Notes						re'd A/18/03/21				
Terms & Condition of Purchasing(Suppliers) and Procurement Quality Clauses are an integral part of our AS9100 requirements. To learn in detail, please visit www.dartaerospace.com for further explanation.										

DAS
38
9-89

Plex 3/16/18 8:50 AM dart.lavoie.chantal

AFFUTAGE K.G. INC.
K.G. GRINDING INC.

40 ans
Depuis 1975

11455 Ave. Philippe Panneton
Montréal, Québec
Canada, H1E 4M1
Tél. : 514-323-0192
Fax : 514-323-6631

Distributeur d'outils de coupe & Affutage sur mesure

Distributor of cutting tools & Custom tooling

**BON DE LIVRAISON
DELIVERY SLIP**

DATE: MAR-14-2018

DART AEROSPACE

73008

P.O. # 39202

[illegible]

REÇU EN BONNE CONDITION / RECEIVED IN GOOD ORDER

www.kggrinding.com • sales@kggrinding.com